Monday, 02/02/2009 11:49:45 AM

Julie Dawson

Process Sheet

Customer

: CU-DAR001 Dart Helicopters Services

Job Number **Estimate Number**

S.O. No. :

: 45382 : 10584

P.O. Number

This Issue

: 02/02/2009 : NC

Prsht Rev. : // First Issue

Previous Run Written By

: 44359

Type

: SMALL /MED FAB

Part Number

Drawing Name

: D1048 : D1048 REV A

: CLAMP

Drawing Number Project Number

: N/A

Drawing Revision

Material

Due Date

: 28/02/2009

: A

Qty:

50 Um:

Each

Checked & Approved By

Comment

Re-format NG : Est: B 02.02.22

Est Rev:C Now on Waterjet 06-12-06 JLM

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

M304S16GA

304/316 Sheet .063



Comment: Qty.:

0.0189 sf(s)/Unit Total:

0.9450 sf(s)

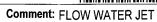
304/316 .063 Sheet

Batch: 11055

2.0

WATER JET

FLOW WATER JET



1-Cut as per Dwg D1048

Dwg Rev:_A

Prog Rev:_A

2-Deburr if necessary

INSPECT PARTS AS THEY COME OFF MACHINE



3.0



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0

QC8

SECOND CHECK



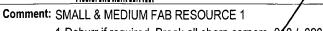


Comment: SECOND CHECK

SMALL & MEDIUM FAB RESOURCE 1



5.0 SMALL FAB 1



1-Deburr if required. Break all sharp corners .010 / .020 as per dwg.



Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES									
DATE	STEP	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
								·			
		,									
									,		
Part No	•	PAR #·	Fault Cate	norv:	NCP: Vos	No DOA	. ,	Data			
				NCR: Yes No DQA: Date: QA: N/C Closed: Date:							
NCR:		,	WORK ORDE	ER NON-CONFORMA	NCE (NCR)					
DATE	STEP	Description of NC		on B	Verifica	ation	Approval Chief Eng	Approval			
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C		QC Inspector			
									:		
				415							

NOTE: Date & initial all entries

	nday, 02/02/2009 11:49:45 AM				
User: Julio	e Dawson		Process Sheet		:
' Customer:	CU-DAR001 Dart Helicopters	Services	Drawing Name: CLAM	D	
for North and	45303		D 4 N 1 D4040		
Job Number:	11861118118181818181818181818181818		Part Number: D1048		
JOD Number.					
Co #		. <mark>!!!!</mark>			
Seq. # :	Machine Or Operation: BRAKE NC		NC BRAKE	<u>n:</u>	
0.0			110 510 112		
Commo	ent: NC BRAKE 1-Form as per dwg D201	Ousing DT9053		FF	9103/06
7.0	QC5	o using D 10000	INSPECT WORK TO CURRENT STEP	100	9703700
					to
					caros
8.0	ent: INSPECT WORK TO CU POWDER COATING	RRENT STEP	POWDER COATING	205(25/06	(620)
0.0		/	FOWDER COATING		·
		m	105642		
Comme	ent: POWDER COATING	" (D (40 C 7)	00100540	•	
	Powder Coat Black Sand	tex (Ref: 4.3.5.7)	as per QSI 005 4.3		(150)
	START TIME:	10:55	1.		
	OVEN TEMPERATURE:	330°	1/20)	0/00/10
9.0	FINISH TIME:	<u># 20</u>	INSPECT POWDER COAT/CHEMICAL	CONVERSION	9/03//0
5.5					
			M.V.		
	ent: INSPECT POWDER CO	AT/CHEMICAL CO		9-03,1	0 (850)
10.0	PACKAGING 1		PACKAGING RESOURCE #1		
					5 cx
Comme	ent: PACKAGING RESOURC	E #1	1 1		
	Identify and Stock Location:		9/3/10		$\leq l_{\rho}$
11.0	QC21	*	FINAL INSPECTION/W/O RELEASE		
					09/03/11
Comm	IIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIIII				09103111
Comme	ent: FINAL INSPECTION/W/	J RELEASE			
Job Completion				h 09.03	. II
				$\int_{\mathcal{A}} \mathcal{O}(\mathcal{V})$, fr
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W/O:		WORK ORDER CHANG	WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
Dort No	_	DAD #			•		1			

Part No: PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
D.47E		Description of NC		Corrective Action Section B	Verification	A					
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector			
						1					
								,			
								>			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 45382
Description: CLAMP	Part Number: D1048
Inspection Dwg: DIO니용 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.750	+1-0.010	0.746	/		VOIN	
2.125	41-0.010	2.123	V		Youn	
1.705	4-0.00	1.704	√		YWN	
0.375	+1-0.010	0.372	√		VerN	
+38	1 0 035		,			
\$ 0.203	+0.005-0.001	0.205	√		Nowy	
				<u> </u>		
	· ·					
						Λ [

	n II				1
Measured by:	m . M	Audited by:	Prototype Approval:	a	
Date:	09 03 05	Date: 6,03/65	Date:	ł	9

Rev	Date	Change	Revised by	Approved
Α		New Issue	KJ/JLM	



NOTES:

.125-

.900

-063 RDB

.250-RAD.

1.800

TO AMENDMENT



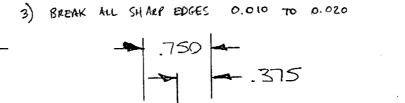
) MATERIAL

STAINLESS STEEL

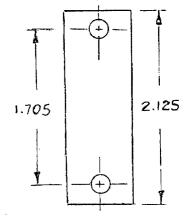
T304#ZB .062 THICK

FINISH: POWDER COAT BLACK SANDTEX (REF. 4.3.5.7)

PER DART QSI 005 4.3



.203 DIA. ZHOLES.





	REVISION	1		RIVET CODE SHAL	L DE PER NAS 523	PARTING.	пем	DESC	RIPTION	1	MATERIAL	SPEC_/VENDOR
RF	DRAWN .	THIS DRAWNIG IS PRIVATE AND CONFIDENTIAL AN IT IS NOT TO BE USED FOR ANY PLIAPOSE OR COP WITHOUT THE PERMISSION OF GART AERO.	BASIC CODE	DAL DASH NO. NºHEAD NEAR SIDE FºHEAD FAR SIDE	CONTRACT NO.			M		DART AERO ACCESSORIES IN		
#	APPROVED	REQUIREMENTS — UNLES		D=OMFLE DIGIT=NO OF SHEETS	LENGTH DASH NO.	BRANKE	7	OATE -	DAI	RYP VA	NCOUVER	CANADA
OS AT PATTER	OF SUMMER ROLL SHAPE SHA	GENERAL 1. DEMENSIONS ARÉ IN INCHES 2. SURFCE ROUGHNESS '11 3. REMOVE SHARP EDICES : 015 MAX 4. THERADS PER MAI. 5 - 7142 5. HOLLS PER AND 10387	TOLERANCES LCX £ .030 TOLERANCES LCX £ .030 ANGLES LOS PARALEUSA LOS ECCEMIRCITY LOS MAX. SYMMATIST ABOUT	C+COUNTERSINK	CODES	BROOLE.		, 1911	mut Cook	CLAMP		
01.12. 400 FLA		REPORT	ALL DISCREPANCIES — DO NO	OT SCALE		CUENT				SCALE 1) \ () 4 : \ SHT	8 A
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0104

Dart Aerospace Ltd

W/O:			WC	RK ORDER CHANG	ES		<u>-</u>		
DATE	STEP	PRO	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector			
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	i								
Part No: PAR #:		Fault Cate	gory:	_ NCR: Yes	No DQA :	Date: _			
	Re	esolution:	Dispositio	Disposition: QA: N/C Closed: Date:					
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (NCR)			
DATE	OTED	Description of NC Corrective Action		Corrective Action Sect	ion B	Verification	Approval	Approval	
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Sign & Section C		QC Inspector	
4.1									
								*	
	1		1		I			,	

NOTE: Date & initial all entries